

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries





Work Order ID 66585

Tuesday, February 22, 2011 11:46:12 AM

Page 2

Item ID: D2989-041 Accept  Setup Start 
Revision ID:
Item Name: Basket Lid Assembly Stop 
Start Date: 2/23/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 3/4/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00		8 u103108					
125  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							

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Page 3

Item ID:	D2989-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Basket Lid Assembly				Stop	
Start Date:	2/23/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	3/4/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

M 115951.

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1 BR 11-8-8

131



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch *M 116402*

Memo

0.00

Mask lid prior to spray paint black and wing walk as per dwg

A/R Spray paint black batch: *M 116123*

1 of M 11/03/09

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Page 4

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Revision ID:						
Item Name:	Basket Lid Assembly				Stop	
Start Date:	2/23/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	3/4/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							<i>ES 11/03/09</i> ①
141 	Identify as per dwg & Stock Location: <i>G-A</i>	0.00							
Packaging Packaging	Memo <i>w/p 66579</i>	0.00							<i>ES 11/03/09</i> ①
150 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							<i>11/3/10</i> ②

11-03-9

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Tuesday, February 22, 2011 11:46:08 AM

[illegible]**Required Date:** 3/4/2011

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
 10.09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 		Manufactured	No			100	Each	11.0000	2	2		<i>Pl 11.03.07</i>	
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				11					
					63628			2					
					64651			9					
D2506 		Manufactured	No			100	Each	8.0000	1			<i>Pl 11.03.07</i>	
Label Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				8					
					65279			3					
					65539			5					
D2512-7 		Manufactured	No			100	Each	9.0000	1			<i>Pl 11.03.07</i>	
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				9					
					63629			3					
					65540			6					

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Picklist Print

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Page 2

Work Order ID: 66585

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2581

 Mounting Bracket

Manufactured No 100 Each 24.0000 2 2



PPL 11.03.07

Location Loc Qty Loc Code

WA 24
 64112 1
 65950 23

D2989-13

 Rib

Manufactured No 100 Each 6.0000 2 2



(5)
 2

PPL 11.03.07

Location Loc Qty Loc Code

WA 6
 63957 2
 64856 4

D2989-19

 Rib

Manufactured No 100 Each 6.0000 2 2



(2)

PPL 11.03.07

Location Loc Qty Loc Code

WA 6
 63958 2
 65541 4

D3832-3

 Mesh (Lid)

Manufactured No 100 Each 4.0000 1 1



(2)

PPL 11.03.07

Location Loc Qty Loc Code

WA 4
 63234 1
 64372 3

(1)

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Shop Packet Print

Page 2

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Picklist Print

Tuesday, February 22, 2011 11:46:09 AM

Work Order ID: 66585

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-3

Manufactured No

100

Each

15.0000

2

2



Mesh (Lid End)



Pl 11.03.07

Location

Loc Qty

Loc Code

WA

15

46308

1

63053

2

64375

6

64947

6

(2)

D3836-041

Manufactured No

100

Each

3.0000

1

1



Rib Assembly (Basket Lid, LH)



Pl 11.03.07

Location

Loc Qty

Loc Code

WA

3

64292

1

64858

2

(1)

D3836-042

Manufactured No

100

Each

3.0000

1

1



Rib Assembly (Basket Lid, RH)



Pl 11.03.07

Location

Loc Qty

Loc Code

WA

3

64293

1

64859

2

(1)

D3852-041

Manufactured No

100

Each

3.0000

1

1



Rib Assembly



Pl 11.03.07

Location

Loc Qty

Loc Code

WA

3

64290

1

64594

2

(1)

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Picklist Print

Page 4

Tuesday, February 22, 2011 11:46:09 AM

Work Order ID: 66585



Parent Item: D2989-041



Parent Item Name: Basket Lid Assembly

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3852-042

Manufactured No

100

Each

3.0000

1

1



Rib Assembly

PL 11.03.07

Location

Loc Qty

Loc Code

WA

3

64291

1

64593

2

①

Tuesday, February 22, 2011 11:46:09 AM

Shop Packet Print

Page 4

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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-12 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS "RAW" AND CONFIDENTIAL. HAS BEEN SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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8

7

6

5

4

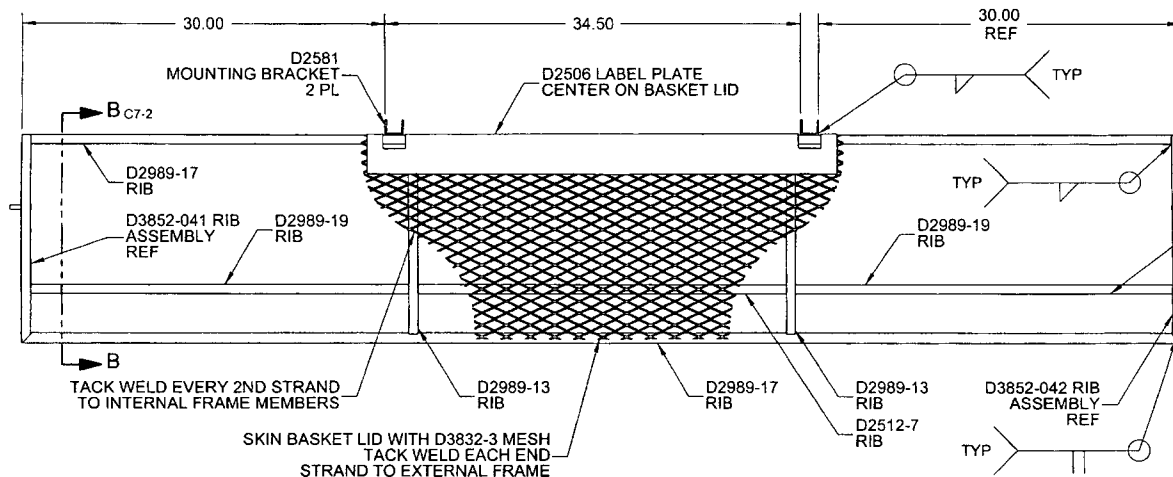
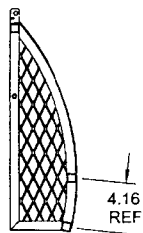
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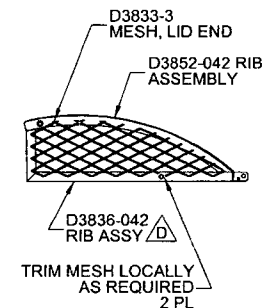
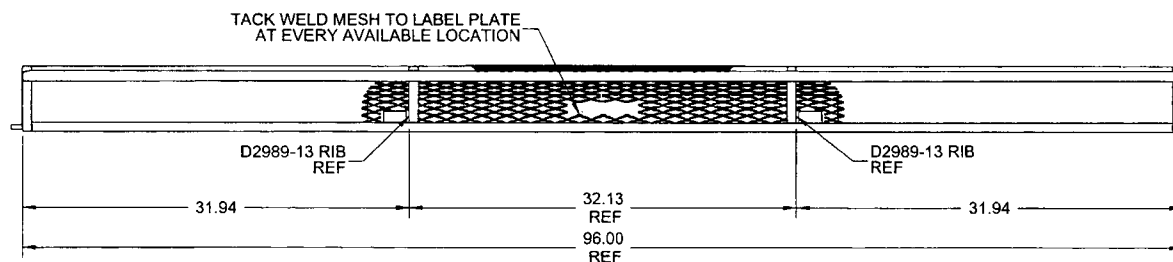
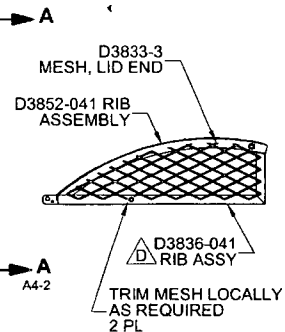
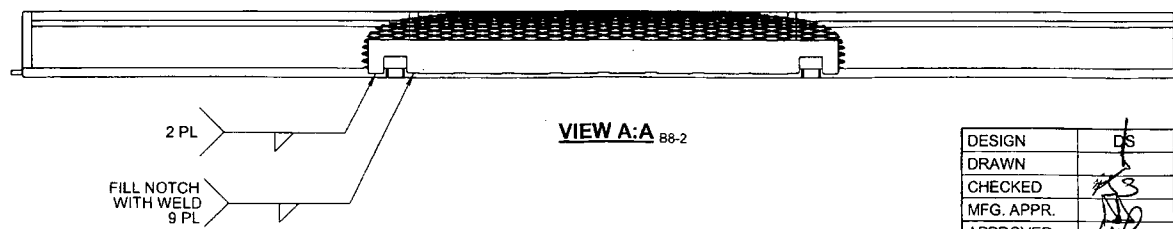
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SECTION B-B

D7-2



#66585

**D2989-041 BASKET LID ASSEMBLY**
(MESH SHOWN LOCALLY FOR CLARITY)**RELEASED**
08/11/84

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	KS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	#	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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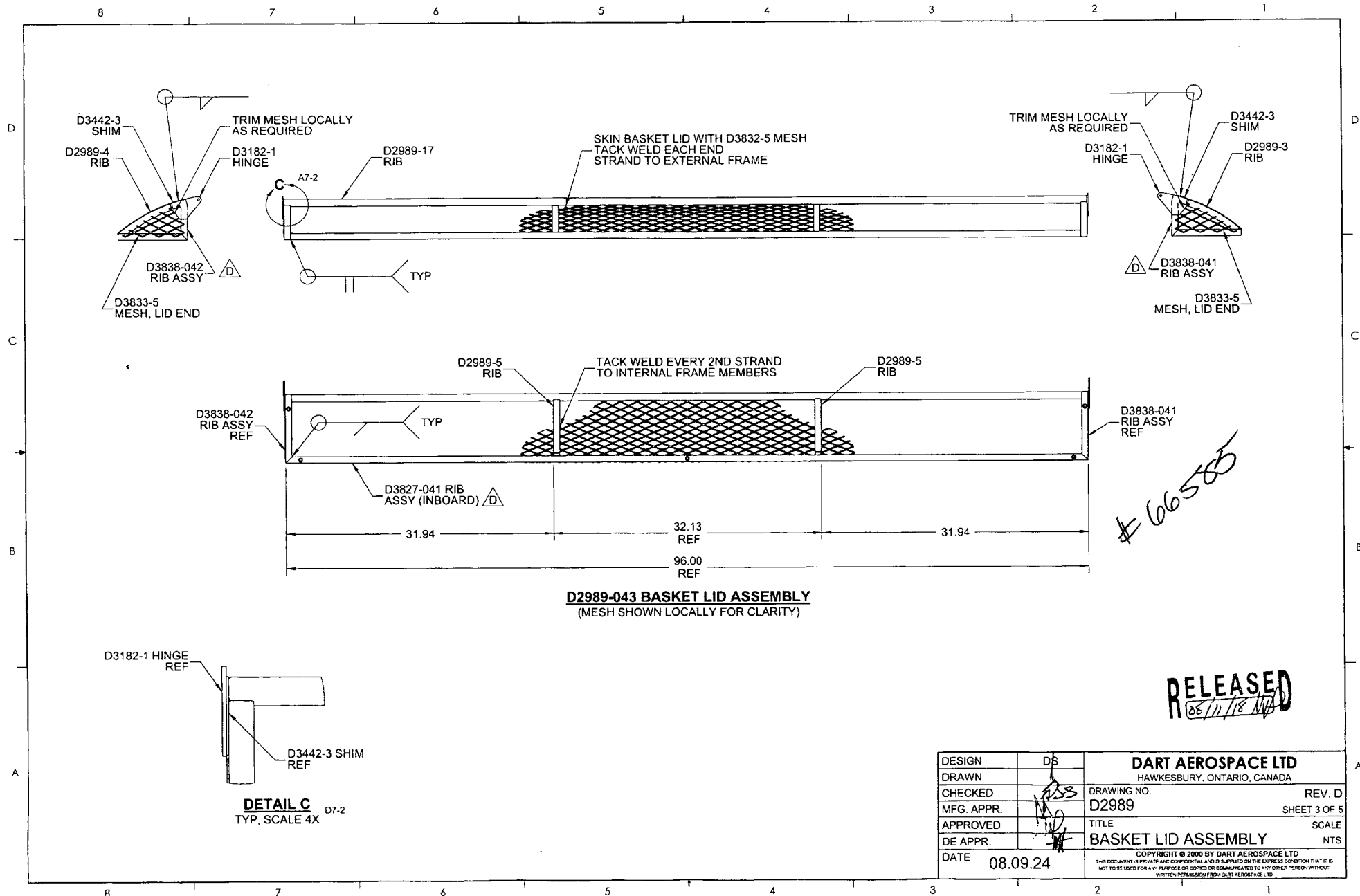
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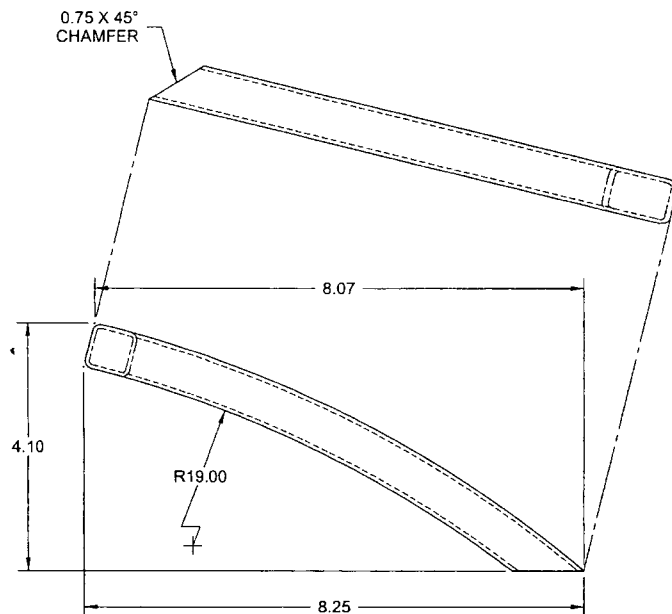
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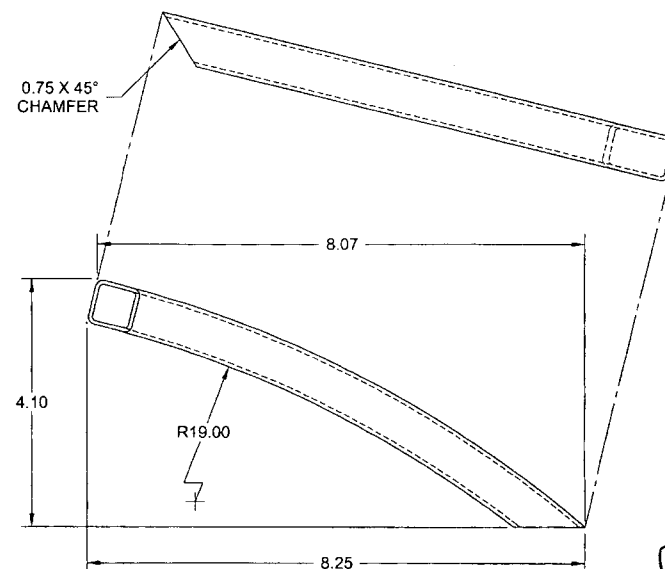
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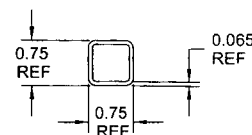
D2989-3 RIB



D2989-4 RIB

#66585

RELEASED
08/11/18/19



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

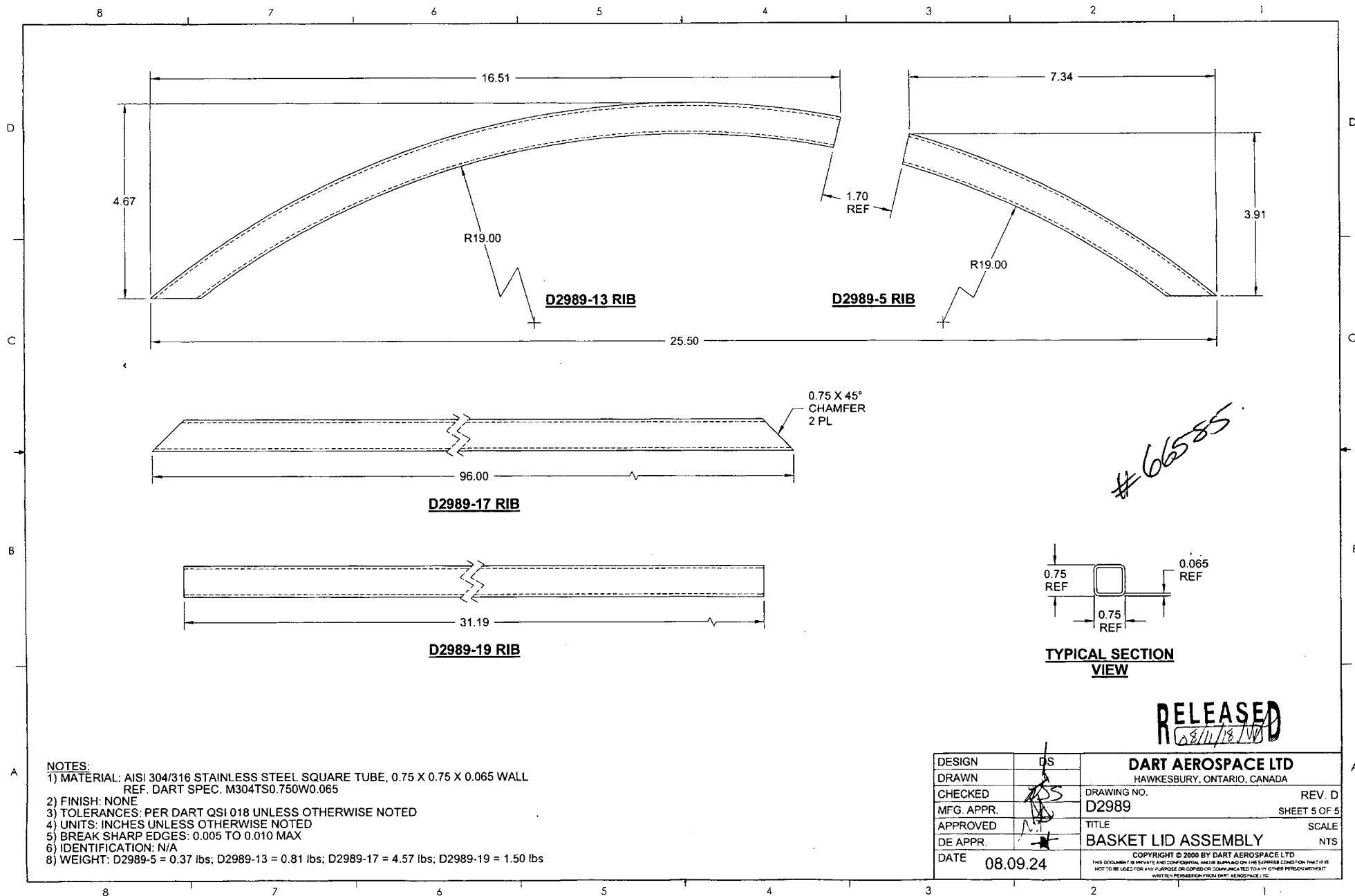
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